

Date: Wednesday, 2/15/2006 3:44:12 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STRUT ASSEMBLY
Job Number	: 25820	Part Number	: D23241
Estimate Number	: 10732	Drawing Number	: D2324 REV. C
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 2/15/2006 S.O. No. : N/A	Drawing Revision	: C
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A	Due Date	: 2/28/2006
Previous Run	: 25048	Qty:	20
Written By	: Spec. comment below.	Um:	Each
Checked & Approved By	: D.J. 06.02.16		
Comment	: Est: E 03.02.28 Reformat; Incorporated D2324-3 & D2324-5 K J/RF		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	25820A	STOP B = B 25820 A (4) B = B 20749 (4)X B = B 23499 (4) (2)	
		Comment: Sub-Component STOP D 2324-3	
2.0	25820B	STRAP	
		Comment: Sub-Component STRAP D 2324 -5 B B 24528	
3.0	AN312A	Bolt	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 40.0000 Each(s) Bolt M 18 369	
4.0	AN960JD10	Washer	
		Comment: Qty.: 4.0000 Each(s)/Unit Total : 80.0000 Each(s) Washer M 19 413	
5.0	MS21042L3	Nut	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 40.0000 Each(s) Nut M 18 615	
6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Assemble as per Dwg D2324.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 06/03/15  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/15/2006 3:44:13 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT ASSEMBLY

Job Number: 25820

Part Number: D23241

Job Number:



Seq. #: Machine Or Operation:

Description :

7.0 QC5

INSPECT WORK TO CURRENT STEP



2060301

Comment: INSPECT WORK TO CURRENT STEP

8.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 06/03/14 (20)

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

DC 06/03/14 (20)

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST169

C Loc 03115 (20)

11.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

(20)  
D 06/03/15

Job Completion



L 06/03/15

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

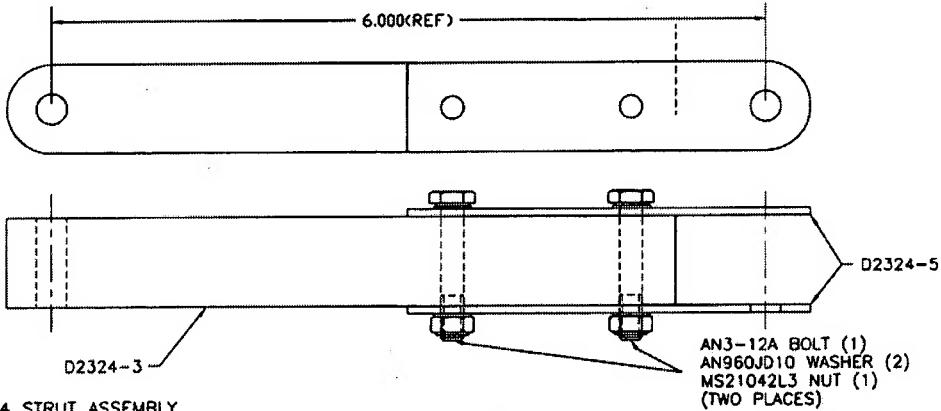
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

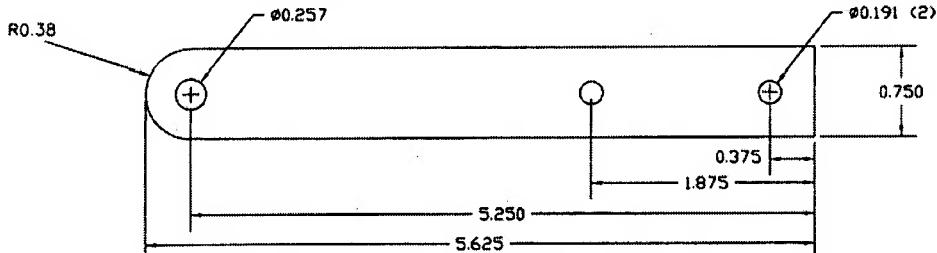
**DART**

DESIGN B WILLIAMS	DRAWN BY PH	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2324
		REV. C SHEET 1 OF 1
DATE 04.12.14		TITLE STRUT
A B C	94.11.08 96.05.07 04.12.14	SCALE NEW ISSUE UPDATE MATERIALS UPDATE NOTES

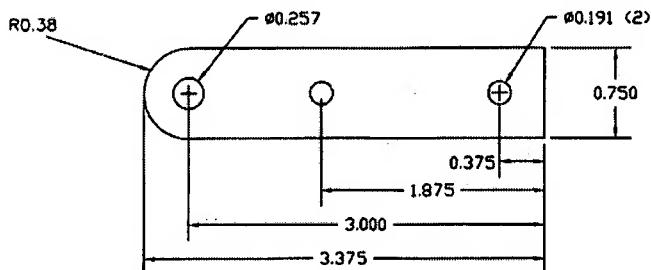
RELEASED

04.12.16 *[Signature]*D2324 STRUT ASSEMBLY

1) IDENTIFY WITH DART P/N D2324 USING FINE POINT PERMANENT INK MARKER

D2324-3

- 1) MATERIAL: 6061-T6/T651 BAR (QQ-A-200/8) 0.75 X 0.75  
(REF DART SPEC. M6061T6B0.750X00.750)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D2324-5

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 16 GAUGE (0.063 THICK)  
(REF DART SPEC. M304S16GA)
- 2) FINISH: POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 25820